

Work Order ID 121095

June-16-14 1:18:16 PM

121095

Page 1

Item ID: D4060-1

Revision ID:

Item Name: Ski Clamp, Top

Start Date: 6/11/14 Start Qty: 40.00

Required Date: 6/16/14 Req'd Qty: 40.00

Reference:

D 40 60 - 1
B 12 1095

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

40

40

Approvals: Process Plan: MLJ Date: 14-06-18 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D4060 | A | | | | | | | | |

100 0.00

100

Purchasing

Purchasing

Memo

Issue P/O: 24657

Manufacture as per Dwg D4060

Supplier: G.F.I

Certificate of conformity is required

0.00

CX 14/06/18 40

110

Receive & Inspect for Damage & Mat'l Certs 0.00

110

Packaging

Packaging

Memo

0.00

P 17/7/11 (40)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
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| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|-----------------------------------------------------|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence |
| | | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge |
| | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |

Work Order ID 121095

June-16-14 1:18:16 PM

121095

Page 2

Item ID: D4060-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Ski Clamp, Top

Start Date: 6/11/14 Start Qty: 40.00

40

Cust Item ID:

Required Date: 6/16/14 Req'd Qty: 40.00

40

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location:

0.00

130

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

DAS
26
9-89

14-7-14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | |
|--------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div> |
|--------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|-----------------------------------------------------|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|

Picklist Print

June-16-14 1:18:15 PM

Page 1

Work Order ID: 121095

121095

Parent Item: D4060-1

D4060-1

Parent Item Name: Ski Clamp, Top

Start Date: 6/11/14

Required Date: 6/16/14

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A new issue DD 10.02.16 verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

D4060-1P

Purchased

No

110

Each

0.0000

1

40

D4060-1P

Ski Clamp, Top

PO 6/17/11 (40)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

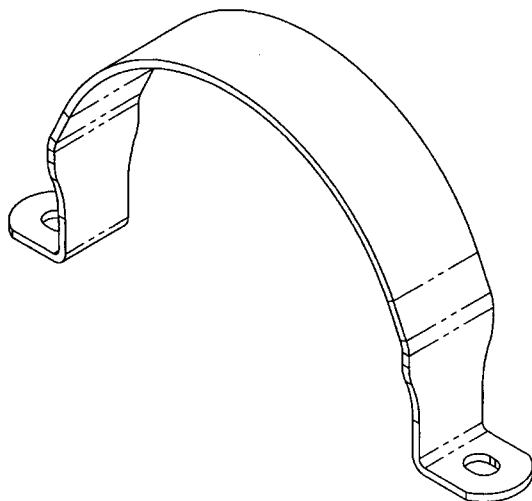
| | | | | | | | | | | | | | | | | | | |
|--------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------------|----------------------------------|----------------------------------------|------------------------------------|----------------------------------------------|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
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| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|-----------------------------------------------------|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

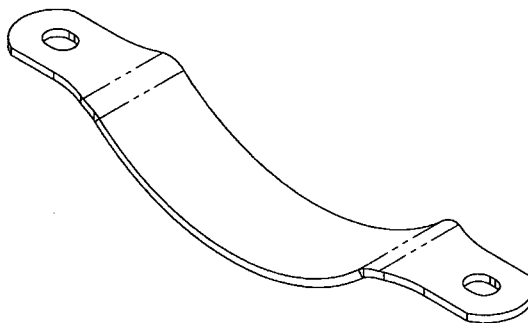
FAULT CATEGORY

| | | |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
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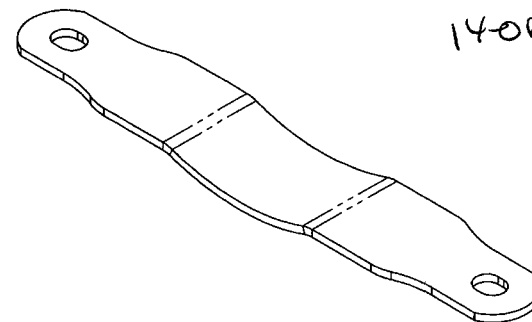
SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 121095 HWS
 1406-18



D4060-1 412 SKI CLAMP, TOP



D4060-3 412 SKI CLAMP, BOTTOM



D4060-5 412 SKI CLAMP, AFT

RELEASED
 2010-04-07

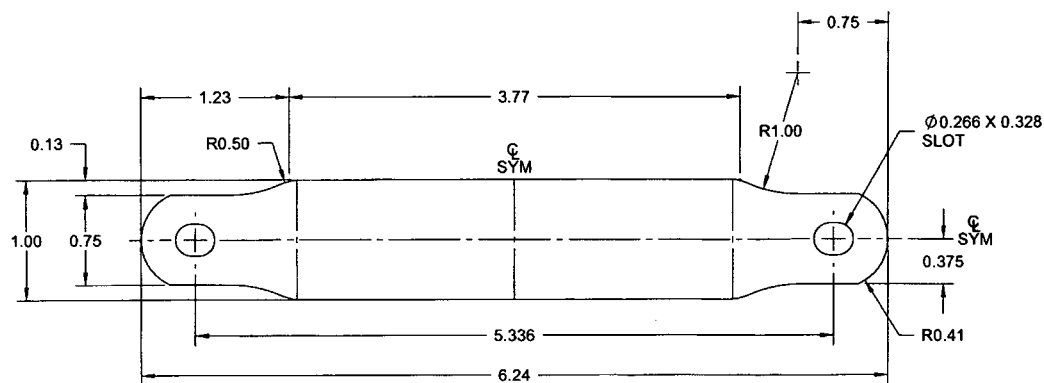
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK)
 PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
 REF. DART SPEC. M304S14GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4060-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D4060-1 = 0.20 lbs, D4060-3/-5 = 0.12 lbs

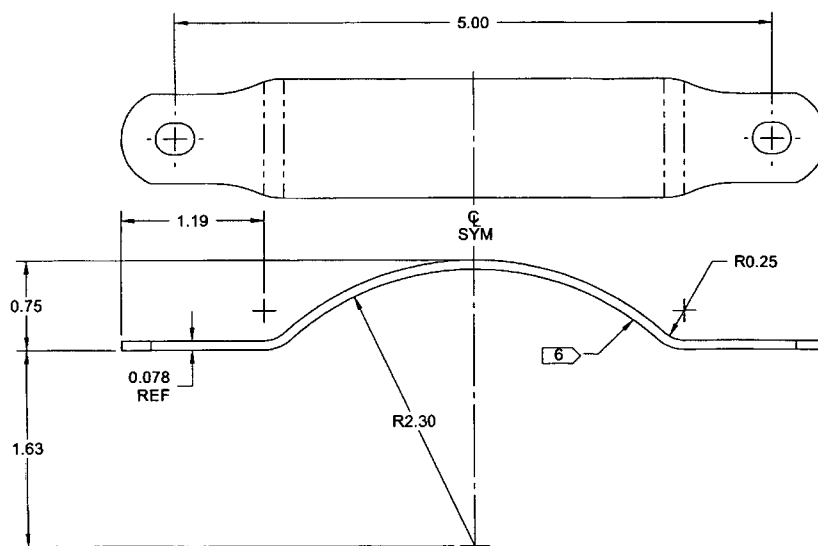
| A NEW ISSUE | | MB 10.03.31 | |
|-------------|-------------|-------------|------|
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 10.03.31 | | |

| | |
|----------------------------------------------------------|--------------|
| DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWING NO. D4060 | REV. A |
| TITLE 412 SKI CLAMP | SHEET 1 OF 4 |
| SCALE NTS | |

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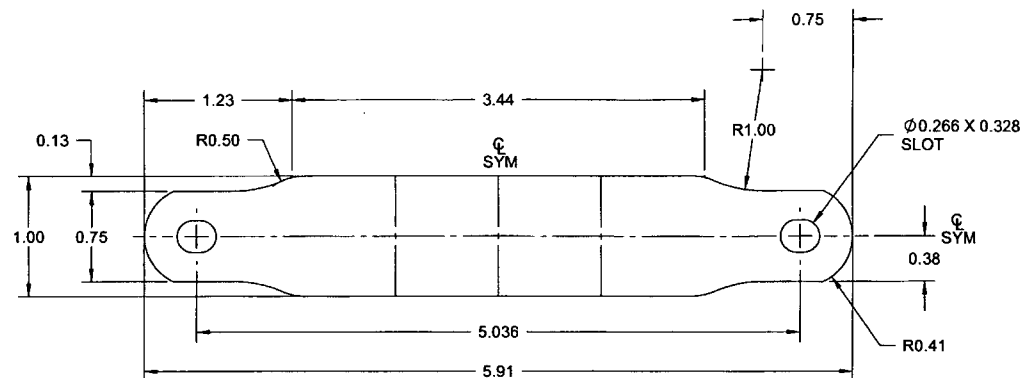
D4060-3F 412 SKI CLAMP, BOTTOM FLAT PATTERN



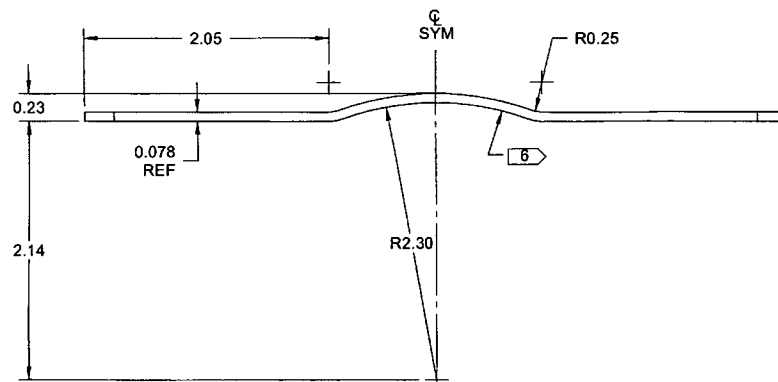
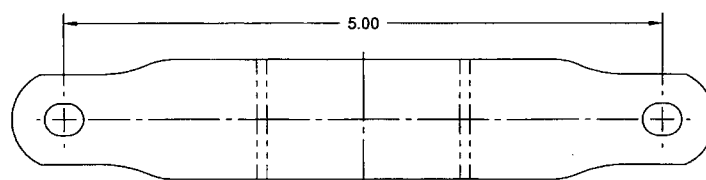
D4060-3 412 SKI CLAMP, BOTTOM
MAKE FROM D4060-3F

RELEASED
2010-04-07

| | | | |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------|----------------------------------------|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D4060 | SHEET 3 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | 412 SKI CLAMP | NTS |
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D4060-5F 412 SKI CLAMP, AFT FLAT PATTERN



D4060-5 412 SKI CLAMP, AFT
MAKE FROM D4060-5F

RELEASED
2010-04-07
MB

| | | | |
|------------|-----------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D4060 | SHEET 4 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | 412 SKI CLAMP | NTS |
| DATE | 10.03.31 | <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A-1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO24657**

Purchase Order Date 6/18/2014

PO Print Date 6/18/2014

Page Number 1 of 2

Order From :
GFI
180 AVENUE LABROSSE
POINTE CLAIRE, QC H9R 1A1
CA

VC-GFI001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED

Contact Name
Vendor Phone 514 630 4877

Ship To Contact
Ship To Phone
Ship Via: FedEx PI collect
Ship Acct:

Buyer
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA - (Free Carrier)

| Line Nbr | Reference Vendor Part Number Line Comments Delivery Comments | Description/ Mfg ID | Req Date/ Taxable Promise Date | CD | Req Qty/ Unit of Measure | PO Unit Price | Extended Price |
|-------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------|--------------------------------------|----|--------------------------------|---------------|-------------------|
| 1 | D4060-1P AS PER DWG D4060 REV. A B121095 | Ski Clamp, Top | 7/14/2014 Yes 7/14/2014 | | 40.00 Each | \$17.00 | \$680.00 |
| Line Total: | | | | | | | \$680.00 |
| 2 | 71401-45 PROCUREMENT QUALITY CLAUSES A005 RIGHT OF ENTRY A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE) A012 CHEMICAL AND PHYSICAL TEST REPORTS A016 PERSONNEL QUALIFICATION A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE) A026 CERTIFICATION OF MATERIAL CONFORMANCE A041 QUALITY MANAGEMENT SYSTEM A042 DART NOTIFICATION BY SUPPLIER A043 RETENTION OF QUALITY DOCUMENT | PROCUREMENT QUALITY CLAUSES | 7/14/2014 No 7/14/2014 | | 1.00 | \$0.00 | \$0.00 |

Note:

6/18/2014



180 AVENUE LABROSSE
POINTE-CLAIRE, QC, CANADA H9R 1A1
TÉL.:(514) 630-4877 - FAX:(514) 630-4849

GFI est une division de Thomas & Betts Limitée / GFI is a division of Thomas & Betts Limited



BON DE LIVRAISON / SHIPPING MEMO

| DATE DE LIVRAISON / SHIPPING DATE | | | N° DE BON DE LIVRAISON / SHIPPING MEMO NO. | | PAGE |
|-----------------------------------|----|----|--------------------------------------------|--|------|
| JR | MO | AN | | | |
| 09 | 07 | 14 | 0540524 | | 1/1 |



VENDU À / SOLD TO

EXPÉDIÉ À / SHIP TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

| CODE DE CLIENT / CUSTOMER CODE | | N° DE CONTRAT / JOB NO | VOTRE N° DE COMMANDE / YOUR PURCHASE ORDER NO | EXPÉDIÉ PAR / SHIP VIA |
|--------------------------------|-----------------------|------------------------|-----------------------------------------------|------------------------|
| DART | | GFI-0299 | 0287795 | PO24657 |
| QUANTITÉ / QUANTITY | N° DE PIÈCE / PART NO | | DESCRIPTION | |
| 40 | D4060-1P | | SKI CLAMP TOP | |
| | | | ITEM 1 | |
| | | | C OF C REQ'D | |
| | | | FAI REQ'D | |

J0287795-001 34 pcs
J0285505-001 4 pcs
MFG. JOB# J0284793-001 QTY 2 pcs
DUE DATE: 14 July 2014

EXPÉDITEUR / SHIPPER

REÇU PAR / RECEIVED BY

DATE

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION.
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. 11 OUR JOB NO J0287795 SHIPPING MEMO 0540524

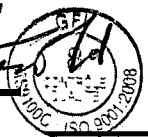
| ITEM | QUANTITY | PURCHASE ORDER | PART NUMBER | REV | NAME | DWG ISSUE |
|------------------------------|----------|-----------------------------|-------------|-----|---------------|-----------|
| - | 40 PCS | PO24657 | D4060-1P | A | SKI CLAMP TOP | A |
| MATERIAL | | SUPPLIED BY | | | MAT. REL. NO. | |
| .078 THK 304 ANN AMS 5513 | | TW METALS/ ALLEGHENY LUDLUM | | | 951264 | |

| | PROCESS | PROCESSOR | RELEASE NOTE # |
|---|------------------------------------------------------------------------------------------------------------|-----------|----------------|
| 1 | FIRST ARTICLE INSPECTION REPORT ON FILE | GFI | N/A |
| 2 | REF. GFI MANUFACTURING JOB NUMBER J0287795-001 (34 PCS), J0285505-001 (4 PCS) AND J0284793-001 (2 PCS). | GFI | N/A |
| 3 | | | |
| 4 | | | |
| 5 | | | |
| 6 | | | |
| 7 | | | |
| 8 | | | |
| 9 | | | |

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 09 JULY 2014

G.F.I. Q.C. REP. *[Signature]*





G'Neaf High-Performance Metals Group

175 TUBEWAY
FOREST PARK GA 30297
Tel: 404-361-5050
FAX: 4043617052

CERTIFICATE OF COMPLIANCE

Your Order Number: 0083098

Our delivery receipt Number: 70521834

Date: 10/22/13

This is to certify that the material shipped against the above order on the above delivery receipt, consisting of:

Quantity: 133.632 LB

Line Number: 1

Grade: 304 S/S SHEET AMS 5513 .080

Part #: TS080481204A

Heat Number: 951264

Specification:

Complies in all respects with the item description.

BY:

Janine Clark

Authorized Test Department Clerk

UNITED PERFORMANCE METALS
This is to certify that in accordance with the records in
our files the material shipped on your purchase order
conforms to the following.

Size: 48 X 120
P.O. #49286228
Part: 50995
Sales # 01198678
Quantity: 3

Description: 304L ANN 077-083 AMS5513
Customer: TM Metals
Shipped: 11/13/2012
Heat: 951264

Authorized Signature
Lynne Harper
Lynne Harper

NOTICE OF SHIPMENT/ PACKING LIST



CERTIFICATE OF TEST

AL 6160-4 1211

| | | | | | | |
|--------------------------------------------------------------------|-------------------------------|------------------------------------|--------------------------------------------------------------------|--------------------------------|-------------------------------------|--------------------------|
| CUST. ORD. NO. & DATE 01021271 | CUST. CODE 08/28/12 110977 | ACCEPTING M.I. VANDERGRIFT, PA. | SHIPPER NO. 556215 | PRODUCT CODE 13020102060000 | M.I. ORDER NUMBER 30-082-678 | DATE SHIPPED 10/15/12 |
| FORMS DISTRIBUTION SOLD TO 1 SHIP 10-10-10 | REPEAT ORDER 82037-9 | DO RATE 26 | GOVT CONTRACT | MATL. 1124 | SHIPPING LOCATION VANDERGRIFT PA | INVOICE 659323 |
| UNITED PERFORMANCE METALS 3475 SYMMES ROAD HAMILTON OH 45015 | | | UNITED PERFORMANCE METALS 3475 SYMMES ROAD HAMILTON OH 45015 | | | |

GRADE AND SPECIFICATIONS CARRIER - GROSS, RONALD, INC.
"ATI 304L" STAINLESS STEEL SHEET C R COILS ANNEALED 2B FIN 3 EDGE (UPM 304L/304/302 LCS) (AMS 2248G) (AMS 5511H) (AMS 5513J) (AMS 5516P) (ASTM-A-262-10 PRA E/SCREEN PRA A) (ASTM-A-666-10) (S-400 DTD 10/10/2011) (ASTM-A-240-12) (S-1000 DATED 8/1/2011) (ASME-SA-240 ED 2010) (10/11/10 EXCEPT UPM 304L/304/302) (UNS S30403) (UNS S30200) (UNS S30400) (UPM-QRS-001) (EN 10028-7:2007-1.4301-2B) (EN 10028-7:2007-1.4307-2B) (PWA 300 REV BK) (F-14, F-17, F-22, F-23, F-MASTER) (CONTROLLED TO PWA LCS REQUIRMENTS)

| ITEM | PCS | DIMENSIONS W/G/L | HEAT # | COIL # | TEST # | GROSS | TARE | NET | THEO | TAG #/ | CD | SKID # |
|-----------------------|-----|------------------|--------|-----------|---------|-------|------|-------|------|--------|----|--------|
| 001 | 1 | 48./080/1327. | 951264 | 09272N145 | 8798038 | 18360 | 50 | 18310 | | 893786 | | |
| C CUST IDENTITY 00718 | | | | | | | | | | | | |
| 1 SKID | | | | | | | | | | | | |

| TYPE HEAT/TEST | -C- | -MN- | -P- | -S- | -SI- | -CR- | -NI- | -MO- | -CU- | -N- |
|----------------|------|------|------|-------|------|-------|------|------|------|-----|
| HEAT 951264 | .019 | 1.77 | .031 | .001 | .45 | 18.24 | 8.06 | .33 | .50 | .07 |
| TEST LOCATION | MI | MI | MI | MI | MI | MI | MI | MI | MI | MI |
| CHECK 8798039 | .016 | 1.76 | .031 | .0004 | .44 | 18.25 | 8.01 | .33 | .51 | .07 |
| TEST LOCATION | TC | TC | TC | TC | TC | TC | TC | TC | TC | TC |

| ITEM TEST NO | YIELD PSI * | TENSILE PSI | % ELONG IN 2" | R/A | HARDNESS | BEND | A 262 PR E | CORROSION | GRAIN SIZE | HARDENABILITY |
|------------------------------|-------------|-------------|---------------|-----------|----------|--------|------------|-----------|------------|---------------|
| 001 8798038 | T 45200. | 95000. | 70. | | 83.HRBW | T PASS | PASS | 8. | | |
| TEST LOCATION | TC | TC | TC | | 84.HRBW | TC | TC | TC | | |
| * Y.S. BY 0.2% OFFSET METHOD | | | | | | | | | | |
| ITEM TEST NO | CORROSION | MELT | T-YIELD | P&W E-25 | | | | | | |
| 001 8798038 | ISO 3651-2 | SOURCE | 1% | TRAN BEND | | | | | | |
| TEST LOCATION | PASS | 1. | 51500. | 2. | | | | | | |
| TEST LOCATION | TC | | TC | TC | | | | | | |

REVIEWED BY Q.C.
Date: 10-18-12 by PE

PAGE 01 - CONTINUED ON PAGE 02

CONSIGNEE-Please Note-This consignment was turned over to carrier in first class condition, being correctly loaded, at which time our responsibility for loss or damage in shipment ceased. For your protection please examine shipment as it arrives. If any shortage or shortage is discovered, have it put in description made by transportation agent on waybill before signing.

Material Safety Data Sheets for this product have been supplied to your Purchasing Department. For an additional copy phone 724-226-5980. CAUTION: Processing these materials forms, dust, or solutions may cause lung disease. See Material Safety Data Sheet for further information.

WARNING

Les fiches d'information-sécurité de ce produit ont été fournies à votre département chargé des achats. Pour obtenir des exemplaires supplémentaires veuillez téléphoner au numéro suivant 724-226-5980. Attention: les traitements effectués en production ou vapours, poussières, ou solutions peuvent, être cause de maladies pulmonaires. Pour plus de renseignements se référer aux fiches d'information-sécurité.

The above is a true copy of data on file. The material and test results conform to the sales contract and specification(s) as set forth in Allegheny Ludlum's Order Acknowledgment.

Stephen Watt
Director, Corporate Quality Assurance

AL 6168-4 1211

Description: 304L ANN 077-083 ANISS513
Customer: TW Metals
Shipped: 11/13/2012
Heat 951284

CARRIER - GROSS, RONALD, INC.

"ATI 304L" STAINLESS STEEL SHEET C R COILS ANNEALED 2B FIN 3 EDGE (UPM 304L/304/302 LCS) (AMS 2248G) (AMS 5511H) (AMS 5513J) (AMS 5516P) (ASTM-A-262-10 PRA E/SCREEN PRA A) (ASTM-A-666-10) (S-400 DTD 10/10/2011) (ASTM-A-240-12) (S-1000 DATED 8/1/2011) (ASME-SA-240 ED 2010) (10/11/10 EXCEPT UPM 304L/304/302) (UNS S30403) (UNS S30200) (UNS S30400) (UPM-QRS-001) (EN 10028-7:2007-1.4301-2B) (EN 10028-7:2007-1.4307-2B) (PWA 300 REV BK) (F-14, F-17, F-22, F-23, F-MASTER) (CONTROLLED TO PWA LCS REQUIREMENTS)

THIS DIN EN 10204:2005 - 3.1 CERTIFICATE OF TEST SHALL NOT BE REPRODUCED EXCEPT IN FULL. FEDERAL LAW PROHIBITS THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULENT STATEMENTS OR ENTRIES ON THE CERTIFICATE AND MAY BE PUNISHABLE AS A FELONY UNDER FEDERAL LAW. ATI AL HOLDS SEVERAL QUALITY CERTIFICATIONS THAT INCLUDE ISO-9001, AS9100, NADCAP, AND ISO/IEC 17025. MATERIAL WAS MANUFACTURED IN ACCORDANCE WITH THE ATI AL QUALITY MANUAL REVISION 20 DATED 02/24/2012.

ATI ALLEGHENY LUDLUM WORKS TO THE ROLLS ROYCE SABRE QUALITY MANAGEMENT SYSTEM.

QUALITY SYSTEM CERTIFIED ACCORDING TO PRESSURE EQUIPMENT DIRECTIVE 97/23/EC, ANNEX I, 4.3 BY TÜV SÜD,
INDUSTRIE SERVICE GMBH, (NOTIFIED BODY 0036).

ATI ALLEGHENY LUDLUM PERFORMS CHEMICAL ANALYSIS BY THE FOLLOWING TECHNIQUES:
C, S BY COMBUSTION/INFRARED

N, O, H BY INERT FUSION/THERMAL CONDUCTIVITY
MN, P, SI, CR, NI, MO, CU, CB, CO, V BY WDXRF
B BY OES
AL AND TI ($\geq 0.10\%$) BY WDXRF, OTHERWISE BY OES
PB, BI, AG BY GFAA

MATERIAL TESTED AT ATI ALLEGHENY LUDLUM GEAE S400 APPROVED FACILITIES (T1225 & T9317)
NATRONA HEIGHTS, PA TECHNICAL CENTER; BRACKENRIDGE, PA AND NEW BEDFORD, MA.

TEST REPORTS
ACCEPTED BY

DEC 28 2012

TW METALS

PAGE 03 - CONTINUED ON PAGE 04

CONSIGNEE: Please Note—This consignment was turned over to carrier in first class condition, being correctly loaded, at which time our responsibility for loss or damage in shipment ceased. For your protection please examine shipment as it arrives. If any shortage or damage is discovered, have a full description made by transportation agent acceptable before signing.

Material Safety Data Sheets for this product have been supplied to your Purchasing Department. For an additional copy phone 724-226-5980. CAUTION: Processing that makes fumes, dust, or solutions may cause lung disease. See Material Safety Data Sheets for further information.

WARNING

Les fiches d'information-sécurité de ce produit ont été fournies à votre représentant chargé des achats. Pour obtenir des exemplaires supplémentaires veuillez téléphoner au numéro suivant 724-226-6980. Attention: les traitements antirouille en production de vapeurs, poussières, et solvants peuvent être cause de maladies pulmonaires. Pour plus de renseignements se référer aux fiches d'information-sécurité.

The above is a true copy of calls on Me. The material and loss results conform to the sales contract and specification(s) as set forth in Alachua County's Order Acknowledgement.

Stephen Wolff - 
Director, Corporate Quality Assurance

UNITED PERFORMANCE METALS
This is to certify that in accordance with the terms in our files the material shipped on your purchase order conforms to the following

Size 48 X 120
P.O.: M49280288
Part#: 50865
Sales #: 01198078
Quantity: 3

Description: 304L ANN 077-093 AMS5513
Customer: TW Metals
Shipped: 11/13/2012
Heat: 951284

Authorized Signature
Lynne Harper
Lynne Harper

NOTICE OF SHIPMENT/ PACKING LIST



CERTIFICATE OF TEST

AL 6168-4 1211

| | | | | | | | | | | | | | |
|-------------------------------------------------------------------------------|--|-------------------------------|--|-------------------------------------------------------------------------------|--|-------------------------|--|--------------------------------|--|---------------------------------|--|--------------------------|--|
| CUST. ORDR NO. & DATE 01021271 | | CUST. CODE 08/28/12 110977 | | ACCEPTING MILL VANDERGRIFT, PA. | | SHIPPER NO. 556215 | | PRODUCT CODE 13020102060000 | | MILL ORDER NUMBER 30-082-678 | | DATE SHIPPED 10/15/12 | |
| FORMS DISTRIBUTION SOLD TO 1 SHIP TO 1 SPEC TO | | REPEAT ORDER 82037-9 | | DO RATE 26 | | PRI. UNIT PRIME SEC. | | MATERIAL 1124 VANDERGRIFT | | SHIPPING LOCATION PA | | INVOICE 659323 | |
| SOLD TO UNITED PERFORMANCE METALS 3475 SYMMES ROAD HAMILTON OH 45015 | | | | SHIP TO UNITED PERFORMANCE METALS 3475 SYMMES ROAD HAMILTON OH 45015 | | | | | | | | | |

GRADE AND SPECIFICATIONS

"ATI 304L" STAINLESS STEEL SHEET C R COILS ANNEALED 2B FIN 3 EDGE (UPM 304L/304/302 LCS) (AMS 2248G) (AMS 5511H) (AMS 5513J) (AMS 5516P) (ASTM-A-262-10 PRA E/SCREEN PRA A) (ASTM-A-666-10) (S-400 DTD 10/10/2011) (ASTM-A-240-12) (S-1000 DATED 8/1/2011) (ASME-SA-240 ED 2010) (10/11/10 EXCEPT UPM 304L/304/302) (UNS S30403) (UNS S30200) (UNS S30400) (UPM-QRS-001) (EN 10028-7:2007-1.4301-2B) (EN 10028-7:2007-1.4307-2B) (PWA 300 REV BK) (F-14, F-17, F-22, F-23, F-MASTER) (CONTROLLED TO PWA LCS REQUIREMENTS)

CARRIER - GROSS, RONALD, INC.

ATI ALLEGHENY LUDLUM HOLDS SEVERAL QUALITY AND LABORATORY CERTIFICATIONS THAT INCLUDE ISO-9001, AS9100, AD 2000-MERKBLATT WO, EU PRESSURE EQUIPMENT DIRECTIVE 97/23/EC, NADCAP, ISO/EIC 17025, GEAE S400, GEAE S-1000. REFER TO WWW.ALLEGHENYLUDLUM.COM TO ACCESS THE CURRENT ATI AL QUALITY CERTIFICATIONS.

THE NUMERIC CODES SHOWN UNDER MELT SOURCE CAN BE INTERPRETED AS FOLLOWS:

1. - MATERIAL MELTED, ROLLED AND TESTED IN THE UNITED STATES.
2. - FOREIGN MELT; ROLLED AND TESTED IN THE UNITED STATES.

TESTING WAS PERFORMED AT THE FOLLOWING LOCATIONS:

MI = ATI-ALLEGHENY LUDLUM; 950 TENTH STREET; MIDLAND, PA 15059

TC = ATI-ALLEGHENY LUDLUM; 1300 PACIFIC AVENUE; NATRONA HEIGHTS, PA 15065

TEST REPORTS
ACCEPTED BY

DEC 28 2012

TW METALS

PAGE 04 - FINAL PAGE.

ISSUED BY ATI ALLEGHENY LUDLUM - 10/17/2012 08:20
CARRIE MCFALL - QUALITY ASSURANCE DEPT.

CONSIGNEE- Please Note- This consignment was turned over to carrier in first class condition, being correctly loaded, at which time our responsibility for loss or damage in shipment ceased. For your protection please examine shipment as it arrives. If any shortage or damage is discovered, have a full description made by transportation agent on waybill before signing.

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WARNING

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Stephen Woff
Director, Corporate Quality Assurance